MARLIN .22

The Drop - In Full Auto Conversion

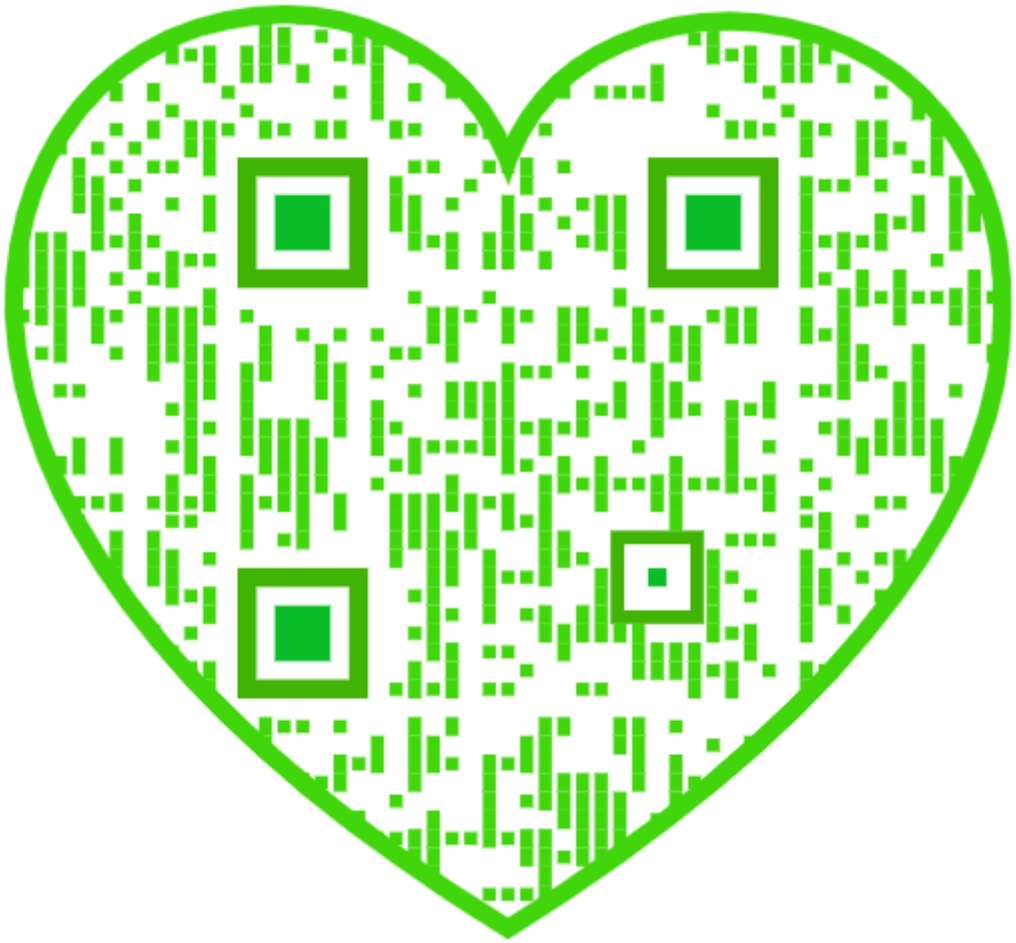
The drop-in conversion kit is primarily designed to convert any of the Marlin or Glenfield self-loaders with detachable magazines to fire straight full auto with a minimal amount of work while using most of the original components. This conversion procedure is best suited for those who just want their basic rifle or takedown carbine to fire full auto. The straight full-auto conversion technique simply requires the drilling of the two small holes at the rear of the bolt to install the filler for open-bolt firing. To reconvert to the original factory closed-bolt system, the two pins that retain the rear filler are simply pushed out and the filler removed from the bolt to allow the clearance for the pivoting hammer.

To complement the "open-bolt" firing system, a new sear that will be engaged with the bolt filler notch (cocking shoulder) must be built. To ensure a quick change from original closed bolt (semiautomatic) to open bolt (full auto), a pair of right-hand-sideplates' magazine guides complete with ejector and recoil buffer must be purchased. When the plates are purchased, it must be specified that the older sideplates without the hold-open device are desired. These parts are twice as thick as the new plates and contain no riveted components (the left-hand plate has the built-in disconnector and riveted pins). The full-auto sear comes complete with its own housing and spring assembly. The preassembled full-auto sear mechanism is simply inserted between the two sideplates, which we will call the "main module." The module contains the magazine housing and ejector assembly. The rear portion of the auto sear housing is now the base of the recoil buffer. The pin that secures the buffer to the main module also retains the auto sear housing at the rear. The front section of the auto sear housing is secured at the front by a separate larger diameter pin.

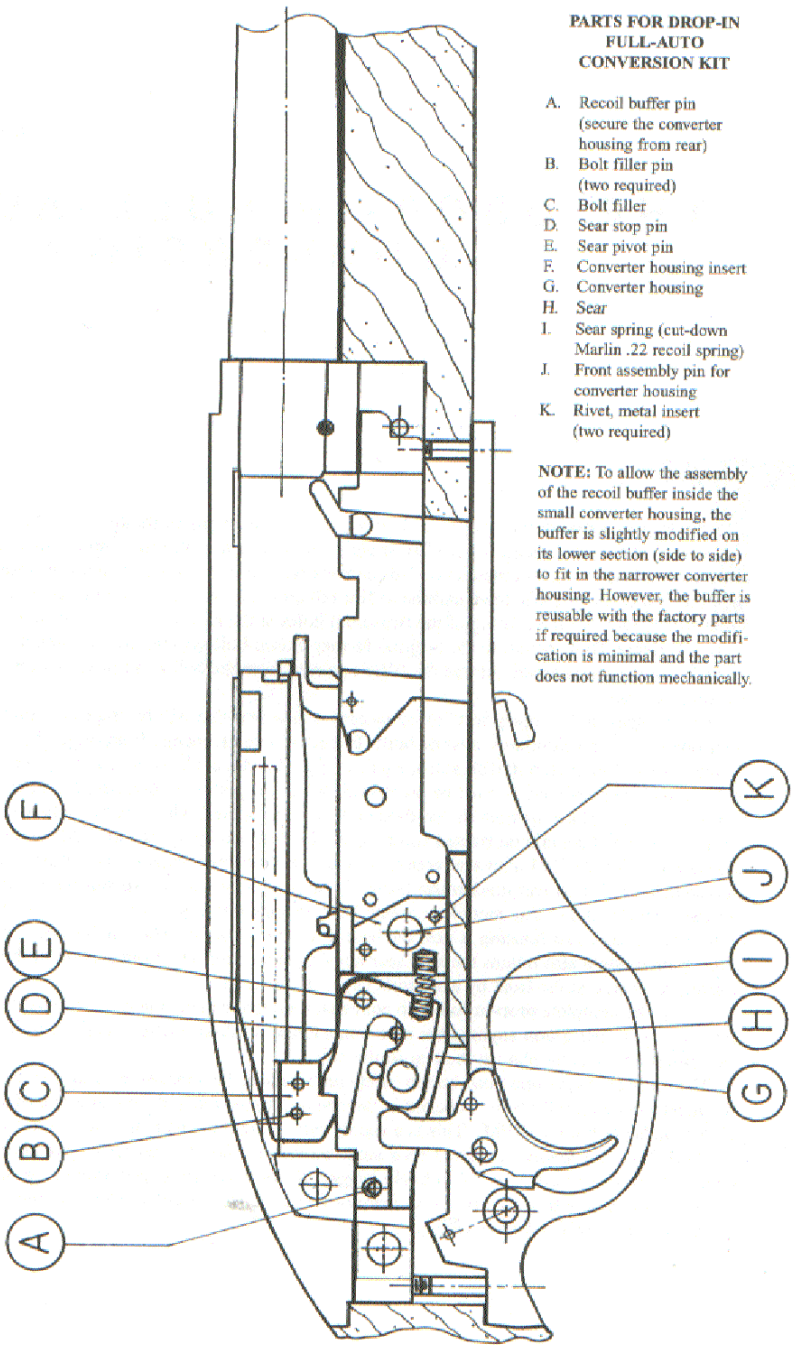
This is the complete drop-in full-auto conversion kit that can be quickly substituted with the separate factory trigger group anytime the user wants to use a full-size rifle or carbine in full-auto mode after installing the filler plate at the rear of the bolt.

The original trigger and push-button safety are retained. This makes the conversion process visually undetectable until the bolt is cocked in the open-bolt position and fired at a rate of 1,500 to 1,700 rounds per minute (RPM). This is a deadly surprise that the bad guys don't want you to have.

CAUTION: *A loaded magazine must never be inserted into the converted gun until the gun is ready to be shot. The safety only blocks the trigger; the bolt may pick up a round from the magazine and fire when the cocking handle is accidentally activated just enough to clear the rear of the magazine to strip a round but fails to engage the sear.*



"DROP IN" FULL AUTO ONLY CONVERSION KIT



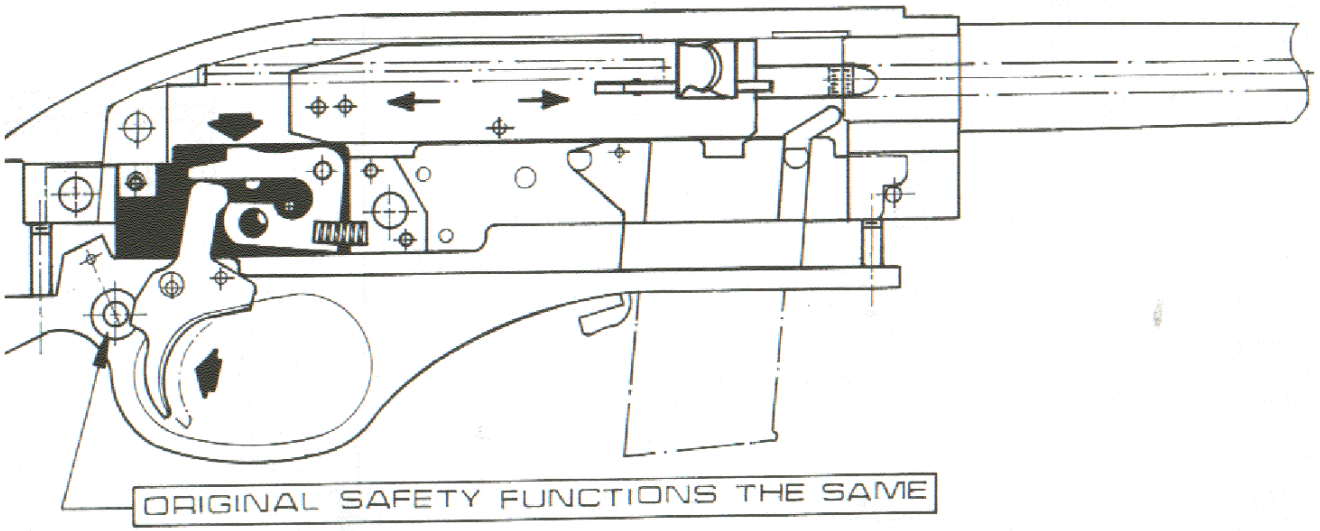
PARTS FOR DROP-IN FULL-AUTO CONVERSION KIT

A. Recoil buffer pin (secure the converter housing from rear)
B. Bolt filler pin (two required)
C. Bolt filler
D. Sear stop pin
E. Sear pivot pin
F. Converter housing insert
G. Converter housing
H. Sear
I. Sear spring (cut-down Marlin .22 recoil spring)
J. Front assembly pin for converter housing
K. Rivet, metal insert (two required)

NOTE: To allow the assembly of the recoil buffer inside the small converter housing, the buffer is slightly modified on its lower section (side to side) to fit in the narrower converter housing. However, the buffer is reusable with the factory parts if required because the modification is minimal and the part does not function mechanically.

FULL AUTO ONLY-OPERATION

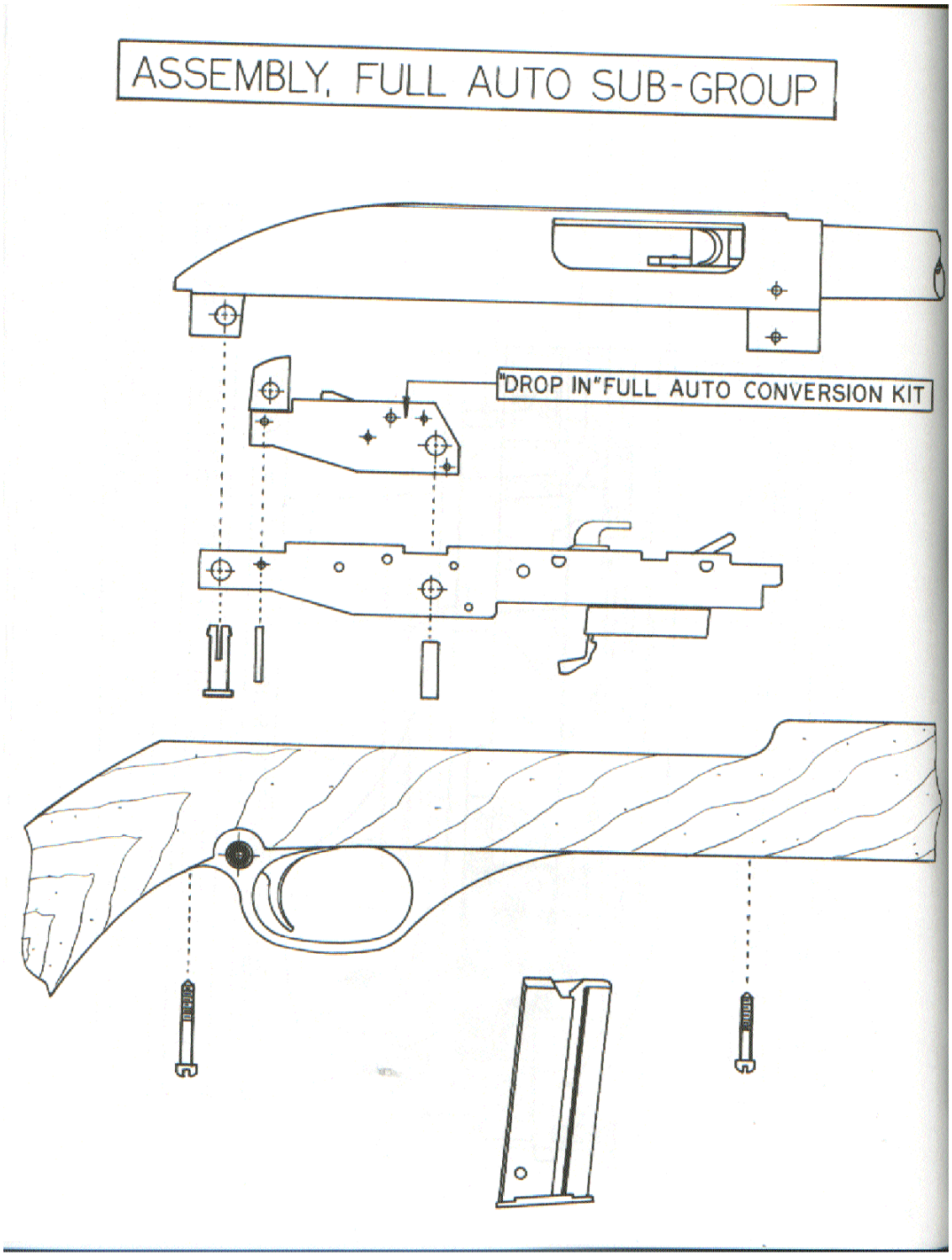
FOR DETACHABLE MAG-FEED MODELS

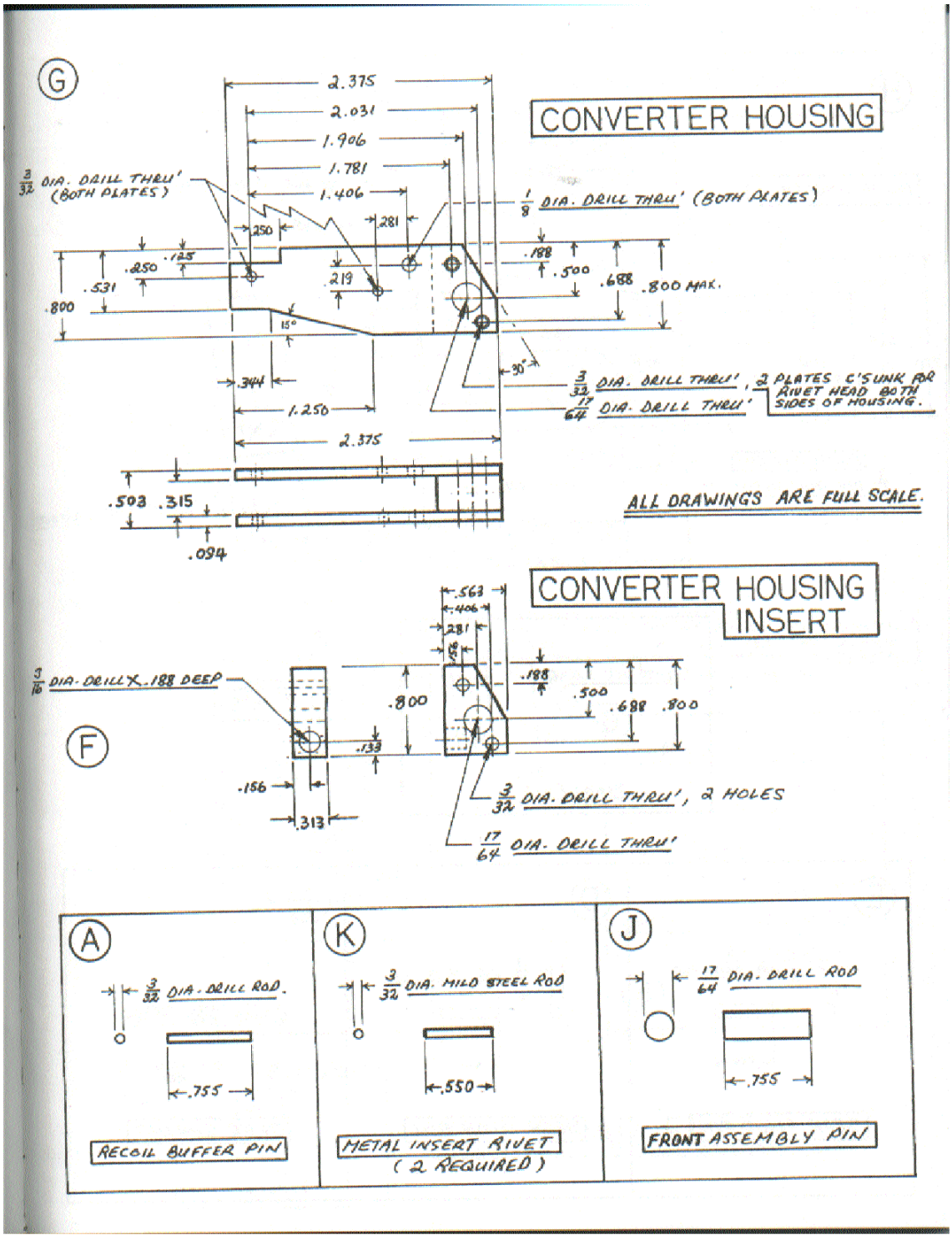


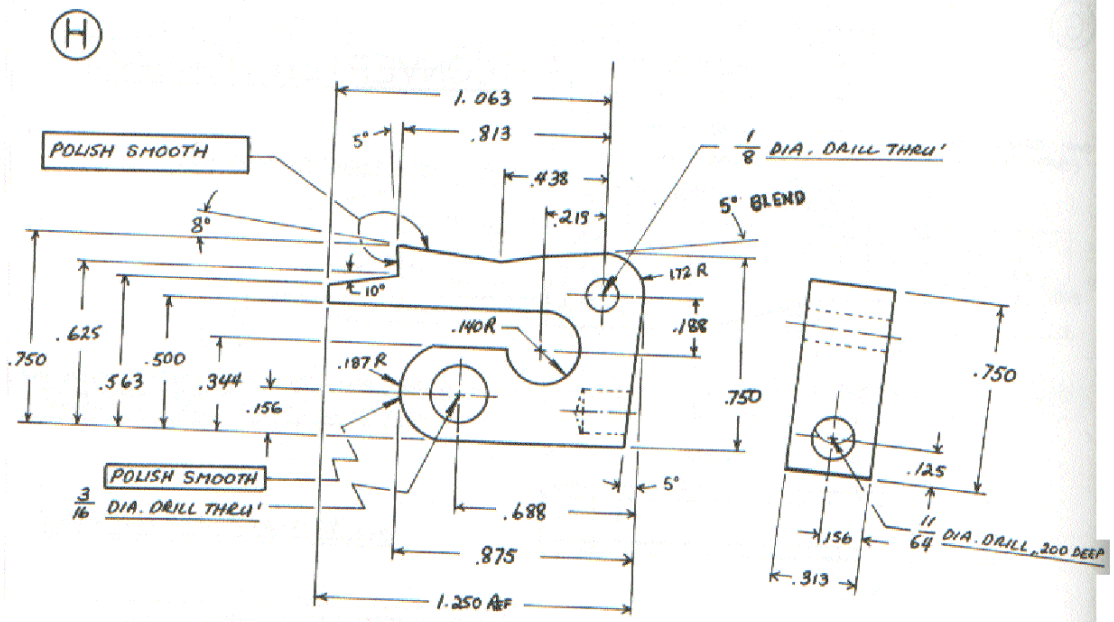
ORIGINAL SAFETY FUNCTIONS THE SAME

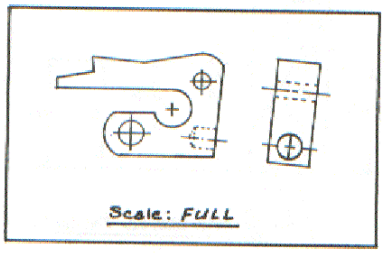
DIRECT CONVERSION TO STOCK GUN

ASSEMBLY, FULL AUTO SUB-GROUP

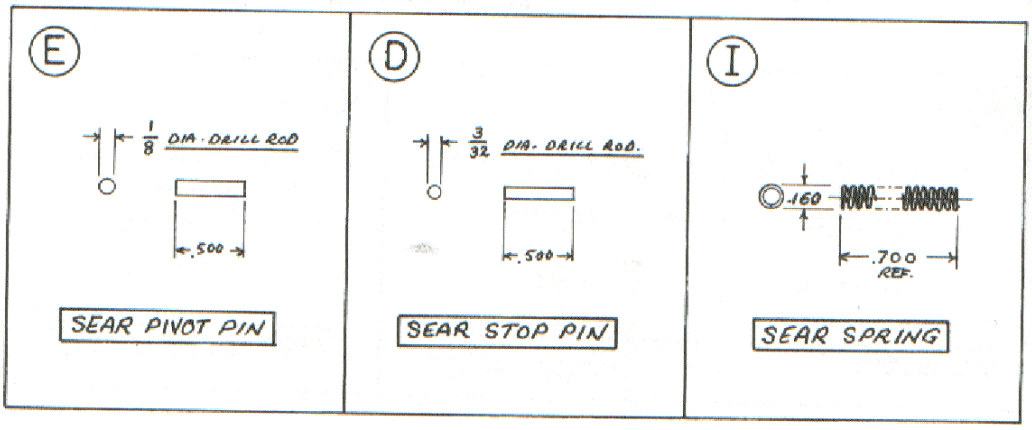



G
CONVERTER HOUSING
2.375
2.031
1.906
1.781
1.406
3/32 DIA. DRILL THRU' (BOTH PLATES)
1/8 DIA. DRILL THRU' (BOTH PLATES)
.281
.250
.125
.250
.531
.800
.219
.188
.500
.688
.800 MAX.
15°
30°
.344
1.250
2.375
3/32 DIA. DRILL THRU', 2 PLATES C'SUNK FOR RIVET HEAD BOTH SIDES OF HOUSING.
17/64 DIA. DRILL THRU'
.503
.315
.094
ALL DRAWINGS ARE FULL SCALE.
CONVERTER HOUSING INSERT
.563
.406
.281
.156
.188
.500
.688
.800
3/16 DIA. DRILL X .188 DEEP
F
.800
.133
.156
.313
3/32 DIA. DRILL THRU', 2 HOLES
17/64 DIA. DRILL THRU'
A
3/32 DIA. DRILL ROD.
.755
RECOIL BUFFER PIN
K
3/32 DIA. MILD STEEL ROD
.550
METAL INSERT RIVET
(2 REQUIRED)
J
17/64 DIA. DRILL ROD
.755
FRONT ASSEMBLY PIN

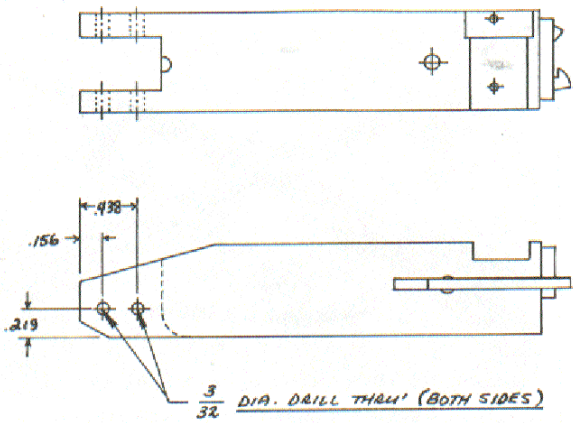

H
1.063
.813
.438
.215
5°
8°
10°
POLISH SMOOTH
1/8 DIA. DRILL THRU'
5° BLEND
.172 R
.140R
.188
.187 R
.750
.625
.563
.500
.344
.156
.750
.750
.125
5°
POLISH SMOOTH
3/16 DIA. DRILL THRU'
.688
.875
1.250 REF
.156
11/64 DIA. DRILL, .200 DEEP
.313


Scale: FULL

SEAR


E
1/8 DIA. DRILL ROD
.500
SEAR PIVOT PIN
D
3/32 DIA. DRILL ROD.
.500
SEAR STOP PIN
I
.160
.700 REF.
SEAR SPRING

NOTE: SAME MODIFICATION & PARTS REQUIRED FOR MACHINEPISTOL BOLT ASSEMBLY.



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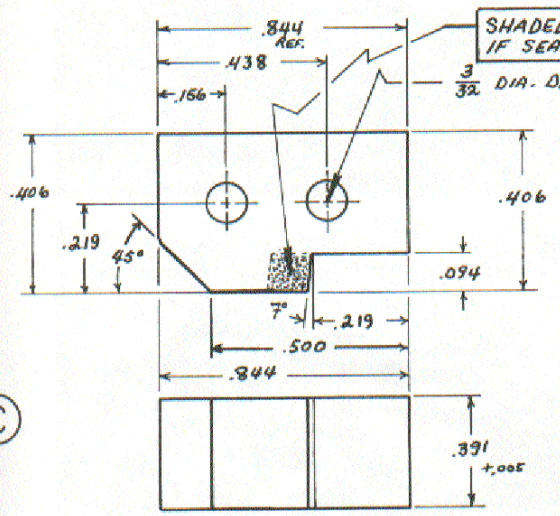
BOLT MODIFICATION



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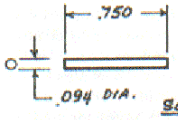
REAR FILLER PIN



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MATERIAL: DRILL ROD OR ROLL PIN. 2 - REQUIRED

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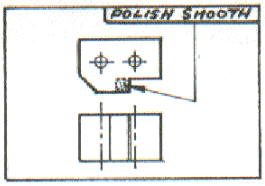

Scale: FULL

BOLT REAR FILLER